

# Work Order ID 74528

Tuesday, October 04, 2011 8:18:24 AM



Page 1

Item ID: D3793-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MLJ Date: 11/10/04 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3793

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3793

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

304 .040

B1-10-31

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B1-10-31

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

M 11 10 31

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 74528

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Page 2

Item ID: D3793-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Brake NC

Brake NC

NC BRAKE

Memo

1-Debur if necessary  
2-Form on Brake as per Dwg D3793 using Jigs

0.00

0.00

SP 11/11/03

(12)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

11.11.03 (12)

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

START TIME: 11:30  
OVEN TEMPERATURE: 320 OF  
FINISH TIME: 12:00

0.00

0.00

12x0 11/11/08

M118489

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 74528**

Tuesday, October 04, 2011 8:18:24 AM



Page 3

Item ID: D3793-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 BR 11-11-8.

170

Identify as per dwg & Stock Location FP1

0.00



Packaging

Memo

0.00

Packaging

12 BR 11-11-8.

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12 11/11/8 MF11-11-08

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, October 04, 2011 8:18:29 AM

Page 1

Work Order ID: 74528



Parent Item: D3793-3



Parent Item Name: Wearshoe

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC  
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

170.5795

1.2828

16.20379



B11-0-31

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

170.5795

116623

0.2

117550

8.363

117933

45.3442

118400

33.6723

118964

83

119346

119346

**Dart Aerospace Ltd**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

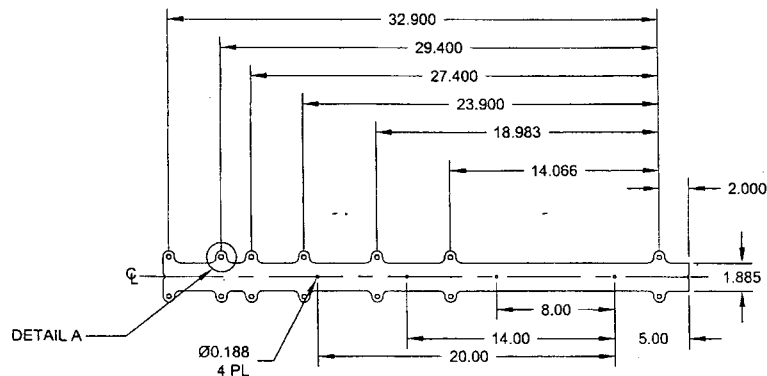
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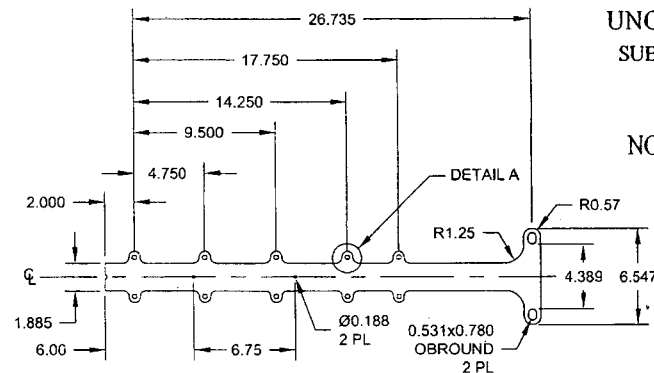
8 7 6 5 4 3 2 1

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 74528ML J.

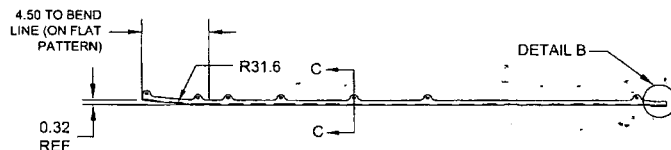
11/10/04



**D3793-1F FLAT PATTERN**



**D3793-3F FLAT PATTERN**



**D3793-1 BEND DETAIL**  
(MAKE FROM D3793-1F)



**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

**RELEASED**  
08-05-23/10

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

REV.	NEW ISSUE	DESCRIPTION	PH	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>		08.05.14
DRAWN	PH	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3793	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		WEARSHOE	NTS	
DATE	08.05.14	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>		

8 7 6 5 4 3 2 1

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

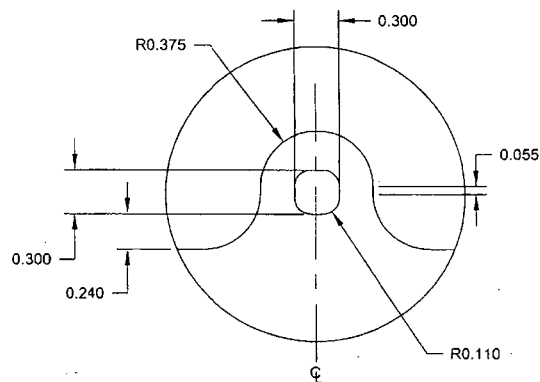
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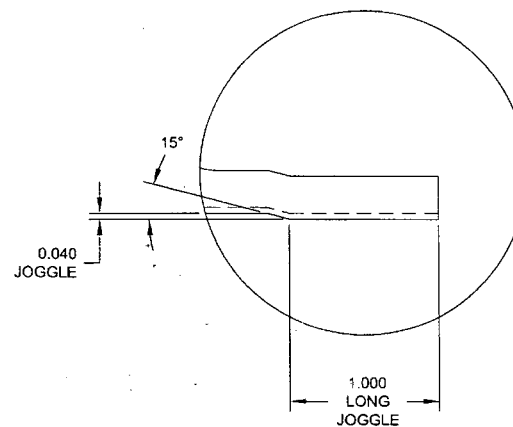
74528

8 7 6 5 4 3 2 1

D



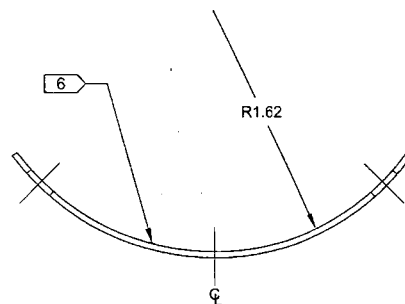
**DETAIL A**  
SCALE 10X



**DETAIL B**  
SCALE 10X

C

B



**SECTION C-C**  
SCALE 10X

**RELEASED**  
08-05-23/14

A

DESIGN	BH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	BH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	08.05.14	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

Dart Aerospace Ltd

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